

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-006384**Date Inspected:** 21-Apr-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1830**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Zhang Huang and Chen Liken**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Joe Alaniz was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The member(s) is/are identified as East Tower Lift 1. The weld designations reviewed are as follows:

Bay 11

1. Skin E Fit lugs and weld between Diaphragm and Face E. (343 welds total)

Bay 11

This QA Inspector observed the following work in progress:

FCAW welding of weld joint 256 located on PCMK WSD1-A423G/H.

Welder is identified as Mr. Zhu Liusheng (068765). ZPMC QC is identified as Mr. Xiao Yun.

The welding variables recorded by QC appeared to comply with WPS-B-T-2133 and WPS-B-T-4133.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

FCAW welding of weld joint 257 located on PCMK SSD1-FESA3-1B/D.

Welder is identified as Mr. Niu Yuehai (066443). ZPMC QC is identified as Mr. Xiao Yun.

The welding variables recorded by QC appeared to comply with WPS-B-T-2231-Tc-U5-F.

Bay 10

FCAW welding of weld joint 110 located on PCMK WSD1-A115F/J.

Welder is identified as Mr. Liu Guoxuan (066279). ZPMC QC is identified as Mr. Zhang Huang.

The welding variables recorded by QC appeared to comply with WPS-B-T-4133.

FCAW welding of weld joint 96 located on PCMK WSD1-A115D/J.

Welder is identified as Mr. Zhu Lisheng (068765). ZPMC QC is identified as Mr. Zhang Huang.

The welding variables recorded by QC appeared to comply with WPS-B-T-4133.

SAW welding of weld joint 14A located on PCMK NSD1-FDSA3-1B/C.

Welder is identified as Mr. Shen Xiaoquan (250522). ZPMC QC is identified as Mr. Zhang Huang.

The welding variables recorded by QC appeared to comply with WPS-B-T-2221-B-U3c-S-2.

SAW welding of weld joint 19 located on PCMK NSD1-FDSA3-1B/C.

Welder is identified as Mr. Zhang Suqin (209051). ZPMC QC is identified as Mr. Zhang Huang.

The welding variables recorded by QC appeared to comply with WPS-B-T-2221-B-U3c-S-2.

FCAW welding of weld joint 067 located on PCMK SSD1-FCSA3-1B/C.

Welder is identified as Mr. Liu Xiaolin (067079). ZPMC QC is identified as Mr. Chen Liken.

The welding variables recorded by QC appeared to comply with WPS-B-T-2232-Tc-U5-F.

FCAW welding of weld joint 30 located on PCMK SSD1-FDSA3-1B/C.

Welder is identified as Mr. Xu Bo (040427). ZPMC QC is identified as Mr. Wen Zhong Wan.

The welding variables recorded by QC appeared to comply with WPS-B-T-2232-Tc-P5-F.

SMAW welding of weld joint 1B located on PCMK ND1-A468-43M-2.

Welder is identified as Mr. Huang Zhao (056200). ZPMC QC is identified as Mr. Wen Zhong Wan.

The welding variables recorded by QC appeared to comply with WPS-485-SMAW-2G (2F)-FCM-Repair-1.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (134-8257-0045), who represents the Office of Structural Materials for your project.

Inspected By:	Alaniz,Joe	Quality Assurance Inspector
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Reviewed By:	Carreon,Albert	QA Reviewer
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